

**Aero Design Ltd.****Work Order Control Sheet**Work Order#: **2017-65** Date Opened: **12 April 2017** Title: **Fabrication**Aircraft OEM: **Multiple** Aircraft Model: **Multiple** Product Type: **Handle Lever Assembly** Product Model: **Multiple** Quantity: **100 L, 100 R****Work Order Contents**

Work Order/Build Sheets (Procedures Provided)  
Additional Work Sheets (Standard Practice)  
Drawings (See List Below)  
Parts Distribution Sheet  
Sub Component Tags  
Completed Certification (Original)  
Time Sheet (R&D)  
Notes

Initial or N/A

DM
N/A
DM
DM
N/A
N/A
N/A
N/A

**Build Sheet Contents**

Tasks Initialled  
Dual Inspections Initialled

Initial or N/A

CB/JC
N/A

**Drawing List**

Drawing #	Rev #	Description	Initial or N/A
84261	2	Handle Bar Assembly	DM

**Traveller**

Weld bushing to lever  
Weld rivet to lever  
Drill bushing to size "O"

Initial or N/A

DM
DM
CB/JC

**Component Completion**

Quantity Complete on This Work Order  
Quantity Incomplete on This Work Order  
Further Processing Required Before Release  
Release to Stock as Components

As Instructed

92L/91R
N/A
N/A
N/A

**Certification**

Form One Completed  
Serviceable (Green) Tag Completed  
In Process (Yellow) Tag Completed  
Unserviceable (Red) Tag Completed  
Parts Placed in Stores for Distribution

Initial or N/A

N/A
CB/JC
DM
N/A
CB/JC

**Additional Documentation**

Documentation of a minor change  
Non-Conformance Report Required  
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

**Billing**

Local (Aero Design)  
Research and Development  
Third Party

Initial or N/A

JC
N/A
N/A

Work performed by:

Print: D Martyn/C BranderSign: SCA: AD05Date: 9 Nov. 2017

ICC / Dual Inspection performed by:

Print: Jeff ClarkeSign: SCA: AD02Date: 10 Nov. 2017

Work Order closed by:

Print: Jeff ClarkeSign: SCA: AD02Date: 10 Nov. 2017

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Handle lever bushing No. of pieces: 38

Manufacturer: Aero Design Ltd.

Part No.: 36274-01 Serial No.: 17024

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-55

Remaining Tasks to be Performed: Weld in place

Signature: David May

Date: April 12/2017 Lic. No. / SCA AD-05



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AMF 73-04

### **Remarks**

**Serviceable**

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AMF 73-04

Nomenclature: Lever Assy. L/H No. of pieces: 67

Manufacturer: Aero Design Ltd.

Part No.: 84261-02 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-65

Remaining Tasks to be Performed: Media Blast, drill, de-burr.  
Tag (Green)

Signature: [Signature]

Date: Sept. 12/2017 Lic. No. / SCA [Stamp]

In Process



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AMF 73-04

**In Process**

**Remarks**

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AMF 73-04

Nomenclature: Lever Assy. RH No. of pieces: 66

Manufacturer: Aero Design Ltd

Part No.: 84261-02 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-65

Remaining Tasks to be Performed: Media Blast, drill, de-burr,  
Tag (Green).

Signature: David Hunt

Date: Sept 12 / 2017 Lic. No. / SCA 73-04  
06

In Process





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AMF 73-04

### Remarks

**In Process**

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## BASKET HANDLE – LEVER ASSEMBLY – 84261-02

### General

These instructions apply to the end bracket used for the handle assembly used on cargo baskets. Refer to the following drawings, at the current revision, for dimensions and details:

36274, Revision 3 – Handle Bushing  
84261, Revision 2 – Handle Assembly

Work Order: 2017-65

Batch Quantity: 92LH 91RH

Complete  
(initial or SCA #)

Date Open: April 12/2017

P.C.W. 2017-55

1. 36274-01 Bushing - Cut stock material:

- Cut 7/16" x 0.065" wall stainless steel tube to 0.75" length.
- Record material PO:
- De-burr cut ends.
- Tag in-progress parts and place on in-progress shelf in machine shop for turning to length.

PO: 17024

2. 36274-01 Bushing - Turn stock material

- Grip tube in collet with a stop inside the collet.
- Turn face flat, just enough to remove cut marks, 0.020 max. Turn at 1030 RPM, at 0.010"/rev feed. Deburr outside and inside. Repeat for entire batch.
- Insert faced end of tube into collet against stop. Turn to finished length of 0.700" at 1030 RPM, at 0.010"/rev feed. Multiple passes may be required to minimize burr. Deburr outside and inside. Repeat for entire batch.
- Tag in-progress parts and place on in-progress shelf in machine shop for welding.

P.C.W. 2017-55

3. 84261-02 Lever Assembly

- Record material POs:
  - 84265-01 Lever (0.125" stainless steel, laser cut):
  - MS20615-4M3 Monel Rivet
  - ER308L Welding rod
- Use jig (??) to set the components at the required depths.
  - Insert MS20615-4M3 monel rivet into small recess, head down
  - Insert 36274-01 Bushing into hole
  - Set 84265-01 Lever over bushing and rivet on jig, tap into place if required.
  - Weld tail of rivet and around bushing on top side only.
  - Make equal quantities of left and right parts.
- Tag in-progress parts and place on in-progress shelf in welding shop for cleanup.

PO: 16072

PO: 13026

PO: 14028

AD  
73-04  
05

4. Clean up

- Media blast completed lever assemblies to remove discolouration around welds and to leave a consistent finish on entire part. Blow off thoroughly after blasting.
- Drill through bushing on lathe using O (0.316") drill at 300 RPM. Grab bushing with chuck, ensure rivet is seated between jaws. Ensure drill is sharp. De-burr if required.
- Tag finished parts and place on in-progress shelf in welding shop for assembly with handle.

AD  
73-04  
02



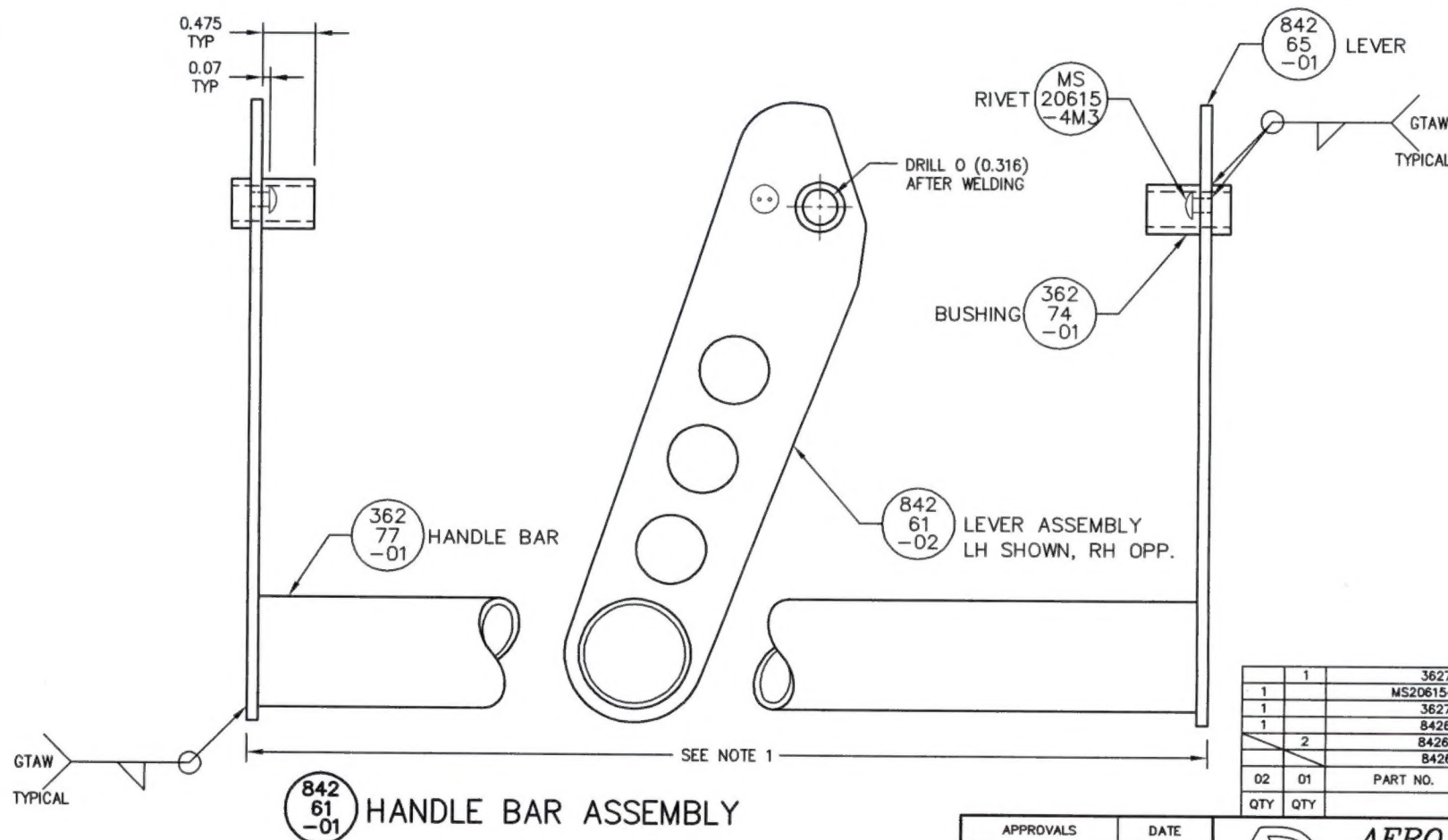


WO# 2017-65

DRM

2017-65

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	HANDLE END BRACKETS FLIPPED	BJC	SEPT 19/11
2	TITLE BLOCK UPDATED; LEVER ASSEMBLY ASSIGNED P/N	BJC	MAR 13/14



## NOTES:

1. LENGTH OF HANDLE TO BE DETERMINED BY BASKET ASSEMBLY DRAWING.
2. REMOVE ALL BURRS AND SHARP EDGES.
3. WELDING TO BE COMPLETED BY GTAW METHOD TO AMS2685C USING ER308L ROD.

QTY	QTY	PART NO.	DESCRIPTION
1	1	36277-01	HANDLE BAR
1	1	MS20615-4M3	RIVET (MONEL)
1	1	36274-01	BUSHING
1	1	84265-01	LEVER
2	2	84261-02	LEVER ASSEMBLY (RH/LH)
2	2	84261-01	HANDLE BAR ASSY

APPROVALS	DATE
DRAWN: R. RATHWELL	JUNE 18/09
CHECKED: E. BURGOIN	

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES.  
TOLERANCES ON:

DECIMALS	ANGLES
X.XXX ±0.010	±1/2°
X.XX ±0.03	
X.X ±0.1	



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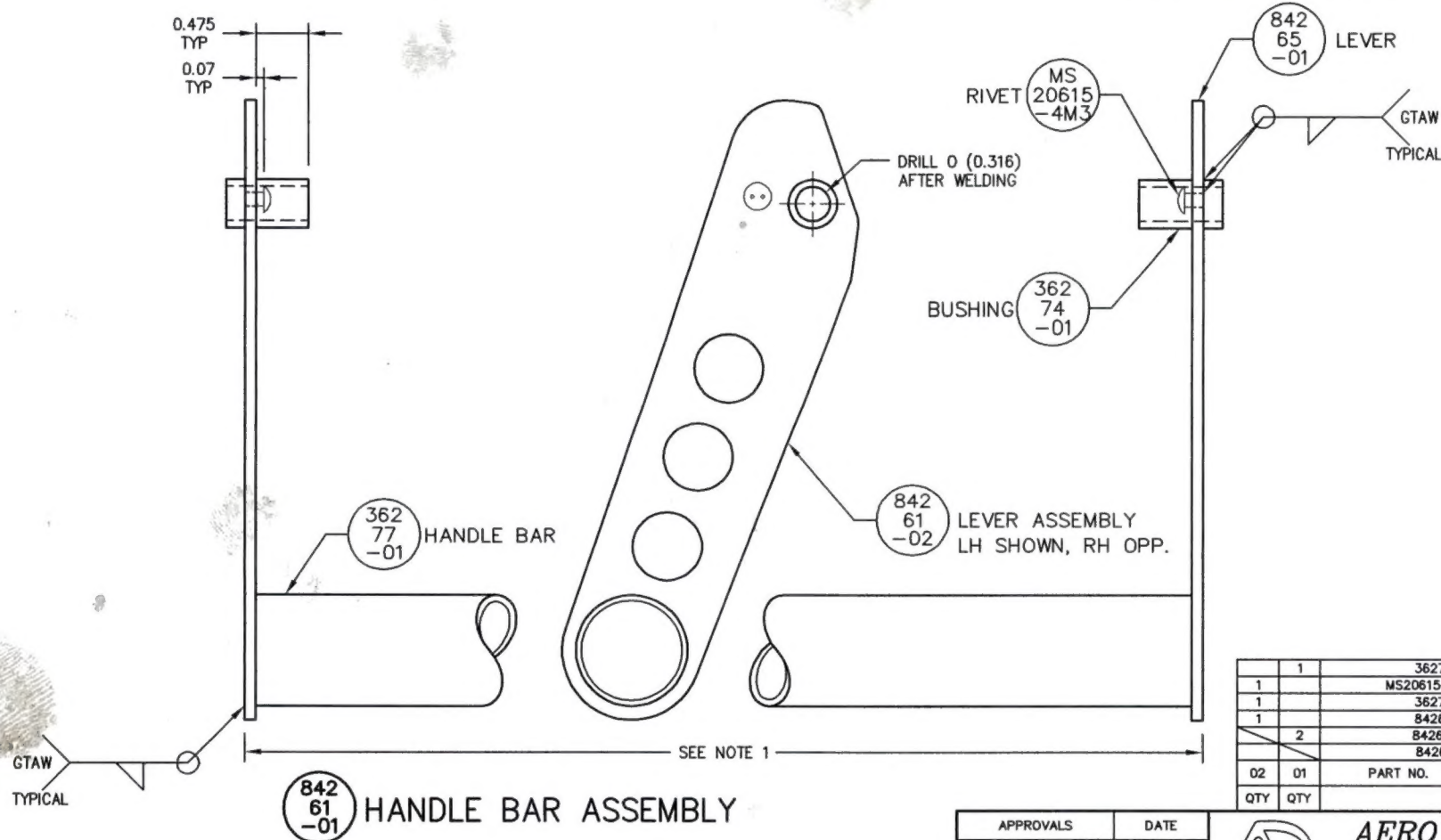
9888A MALASPINA ROAD  
POWELL RIVER, BC, CANADA, V8A 0G3  
TEL: 604-483.5576 www.aerodesign.ca

HELICOPTER CARGO BASKET  
HANDLE BAR ASSEMBLY

SCALE	DWG. SIZE	DWG. NO.	REV.
SCALE 1 : 1	A3	84261	2
SHEET 1 OF 1			

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APPROVALS	DATE
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UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES.  
TOLERANCES ON:  
DECIMALS ANGLES  
X.XXX ±0.010 ±1/2°  
X.XX ±0.03  
X.X ±0.1



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**HELICOPTER CARGO BASKET  
HANDLE BAR ASSEMBLY**

SCALE	DWG. SIZE	DWG. NO.	REV.
SCALE 1 : 1 SHEET 1 OF 1	A3	84261	2